

Work Order ID 58954

Page 1

Thursday, May 20, 2010 10:35:00 AM

Item ID: D2989-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Basket Lid Assembly

Start Date: 5/26/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 6/10/2010 Req'd Qty: 1.00



Customer:

Reference:

Run Start

Approvals: Process Plan: HP Date: 10-5-20 Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D2989	Rev D
-------	-------

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble all ribs in DT9446 jig, weld as per dwg D2989
2- tack weld mesh on basket as per dwg D2989 using DT9446 jig
3- to locate hinges and shims use D2989-041, weld as per dwg D2989
A/R ER316 S.S. Rod Batch: M 113328

SM 10/06/28 (12)

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

CP 10-06-28

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

5/10/04/29

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

Memo

0.00

Powder Coating

1- Plug holes prior to powder coating

2-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

M114841

1ST COAT

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

***** 2nd coat if necessary*****

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9:20
10:30
9:30

N/A

BR 10-6-30

BR 10-6-30

PTC

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
1007-06	130	Add pressure wash step. Perm. change		10.06.07		 100706	 100706	

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Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140



QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

GP 06/07/05 @

150

Identify as per dwg & Stock Location: *GA*

0.00

Packaging

Memo

0.00

Packaging

w/o 58941

GP 06/07/05 @

160



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

P 1007-06

CL 10/7/05

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Picklist Print

Thursday, May 20, 2010 10:35:05 AM

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Work Order ID: 58954

Parent Item: D2989-043

Parent Item Name: Basket Lid Assembly

Comments: IPP Rev:I Removed D2989-041 05-11-03 JLM
 IPP Rev:J 08-08-29 revC as per dwg DD verified by:EC
 IPP Rev:K 08-09-24 plug holes prior to powder coating DD verified by:EC
 IPP Rev:L 08-12-02 revD as per dwg DD verified by:

Start Date: 5/26/2010

Required Date: 6/10/2010

Start Qty: 1.00

Required Qty: 1.00

✓ D3182-1	Manufactured	No	100	Each	8.0000	2	
Hinge							
	<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>		
	WA		8				
	57602		8				
✓ D3442-3	Manufactured	No	100	Each	12.0000	2	
Shim							
	<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>		
	WA		12				
	53137		4				
	56204		8				
✓ D3827-041	Manufactured	No	100	Each	10.0000	1	
Rib Assembly (Inboard)							
	<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>		
	WA		10				
	57219		4				
	57802		6				
✓ D3832-5	Manufactured	No	100	Each	5.0000	1	
Mesh (Lid)							
	<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>		
	WA		5				
	57603		2				
	57941		3				

B59185 ② SJ 10/06/23

~~B59185 ②~~ SJ 10/06/23

②
 B59276 ① SJ 10/06/23

B59181 ① SJ 10/06/23

Thursday, May 20, 2010 10:35:05 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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 IPP Rev:K 08-09-24 plug holes prior to powder coating DD verified by:EC
 IPP Rev:L 08-12-02 revD as per dwg DD verified by:

Start Date: 5/26/2010

Required Date: 6/10/2010

Start Qty: 1.00

Required Qty: 1.00

✓ D3833-5



Manufactured No

100

Each

15.0000

2

Mesh (Lid End)

Location

Loc Qty

Loc Code

WA

15

53722

9

57627

6

100

Each

4.0000

1

✓ D3838-041



Manufactured No

Rib Assembly (Basket Lid, LH)

Location

Loc Qty

Loc Code

WA

4

57831

2

58059

2

100

Each

4.0000

1

✓ D3838-042



Manufactured No

Rib Assembly (Basket Lid, RH)

Location

Loc Qty

Loc Code

WA

4

57832

2

58060

2

B 59187 ① 10/06/03

B 59187 ① 10/06/03

B 59188 ① 10/06/03

Thursday, May 20, 2010 10:35:05 AM

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Page 3

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NOTE: Date & initial all entries

D2989-043 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

D2989-041 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 58954
BS10-5-20

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs
- 8) WELD PER DART QSI 004

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D2989-041	BASKET LID ASSEMBLY
2		X	D2989-043	BASKET LID ASSEMBLY
3	1		D2506	LABEL PLATE
4	1		D2512-7	RIB
5	2		D2581	MOUNTING BRACKET
6		1	D2989-3	RIB
7		1	D2989-4	RIB
8		2	D2989-5	RIB
9	2		D2989-13	RIB
10	2	1	D2989-17	RIB
11	2		D2989-19	RIB
12		2	D3182-1	HINGE
13		2	D3442-3	SHIM
14		1	D3827-041	RIB ASSY (INBOARD)
15	1		D3832-3	MESH, BASKET LID
16		1	D3832-5	MESH, BASKET LID
17	2		D3833-3	MESH, LID END
18		2	D3833-5	MESH, LID END
19	1		D3836-041	RIB ASSY (BASKET LID, LH)
20	1		D3836-042	RIB ASSY (BASKET LID, RH)
21		1	D3838-041	RIB ASSY (BASKET LID, LH)
22		1	D3838-042	RIB ASSY (BASKET LID, RH)
23	1		D3852-041	RIB ASSEMBLY
24	1		D3852-042	RIB ASSEMBLY

RELEASED
08/11/8

D	REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); D3836-041 REPLACES D2989-9/-15; D3836-042 REPLACES D2989-10/-15; D3838-041 REPLACES D2989-1/-7; D3838-042 REPLACES D2989-2/-7; D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-2; REMOVED D2327-3 (NOW INSTALLED ON D3836 DWG); D2989-9/-10 (NOW ON D3836 DWG); D2989-1/-2/-7/-15 (NOW ON D3836 DWG) AND D2989-11/-12 (NOW ON D3852 DWG). REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM	MB	08.09.24
C	FRAME MATERIAL WAS 0.060 WALL; MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD	AJS	08.06.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	DS	00.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DS	DRAWING NO.	REV. D
CHECKED	AJS	D2989	SHEET 1 OF 5
MFG. APPR.	MD	TITLE	SCALE
APPROVED	MD	BASKET LID ASSEMBLY	NTS
DE APPR.	MD	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COMPARISONS TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	08.09.24		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

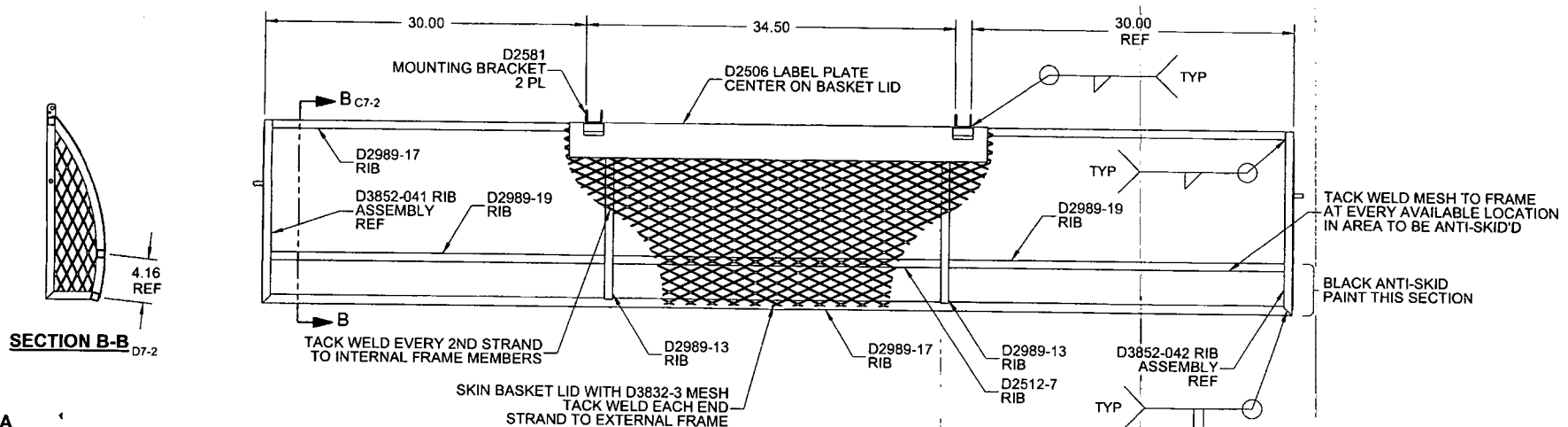
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

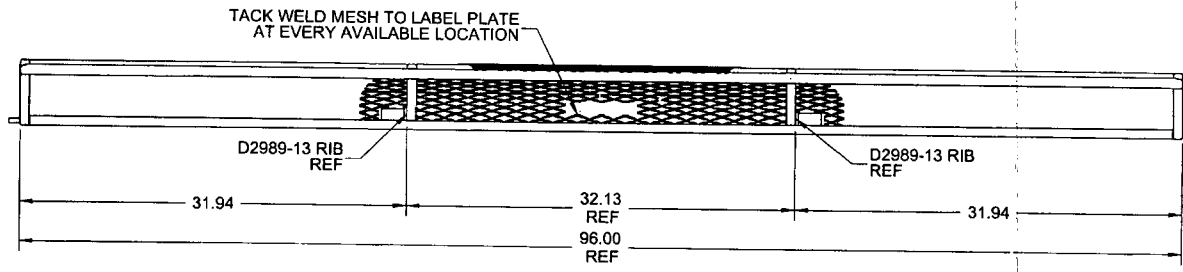
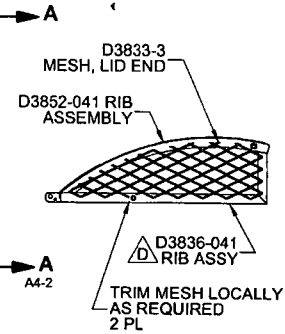
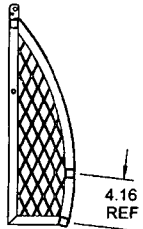
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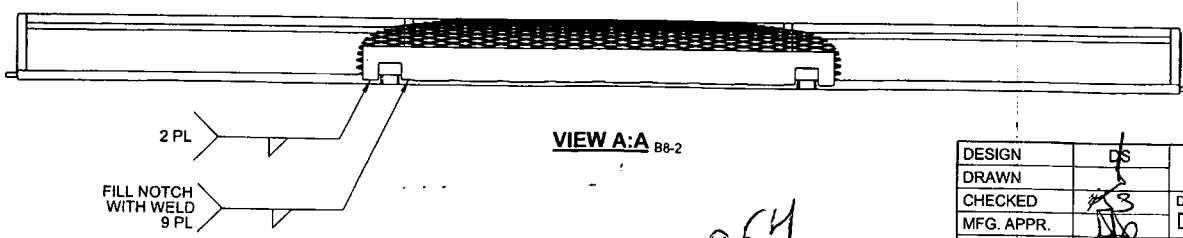
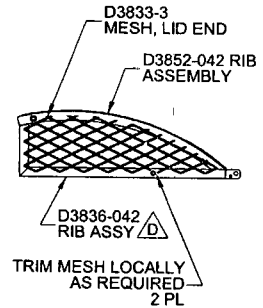
8 7 6 5 4 3 2 1



SECTION B-B
D7-2



D2989-041 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)



VIEW A:A
B8-2

wlb 58954

RELEASED
08/11/18/19

DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	JS	DRAWING NO.	REV. D
MFG. APPR.	JS	D2989	SHEET 2 OF 5
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	BASKET LID ASSEMBLY	
DATE	08.09.24	NTS	
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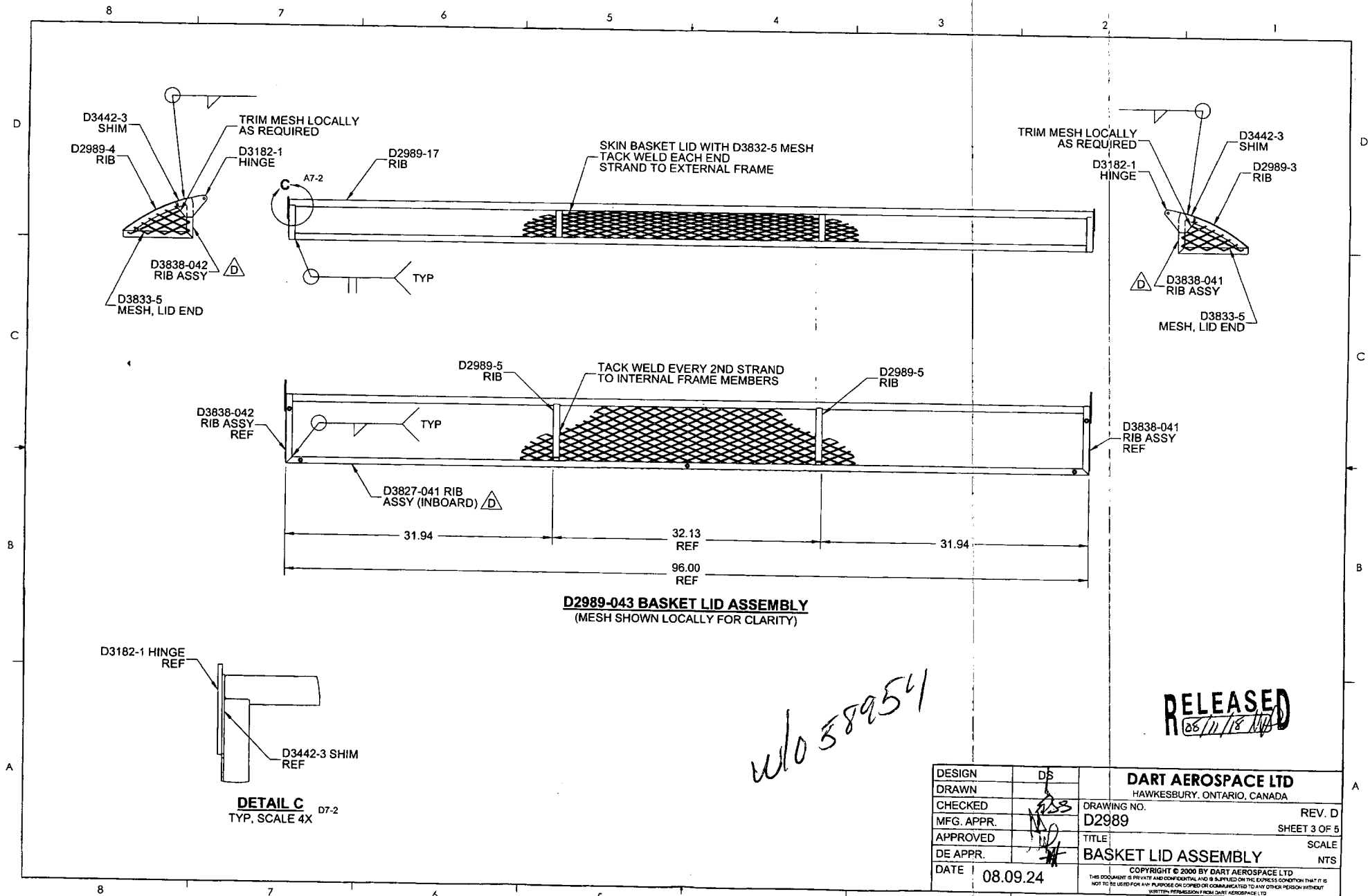
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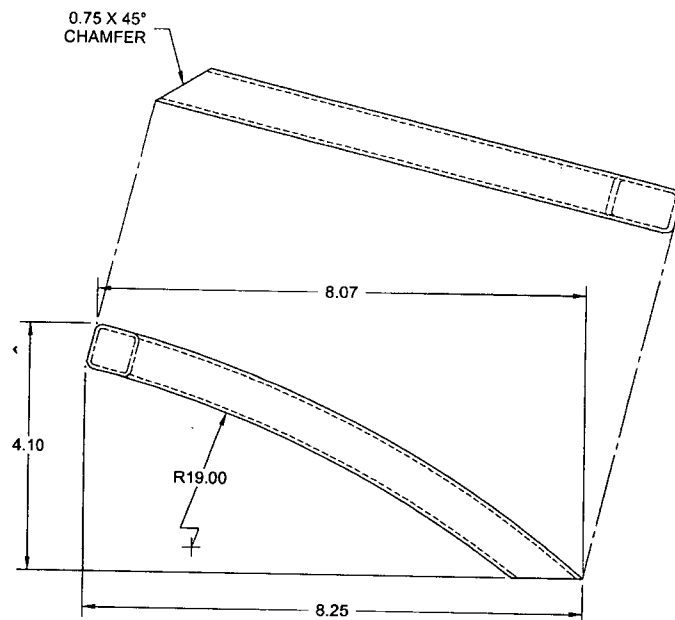
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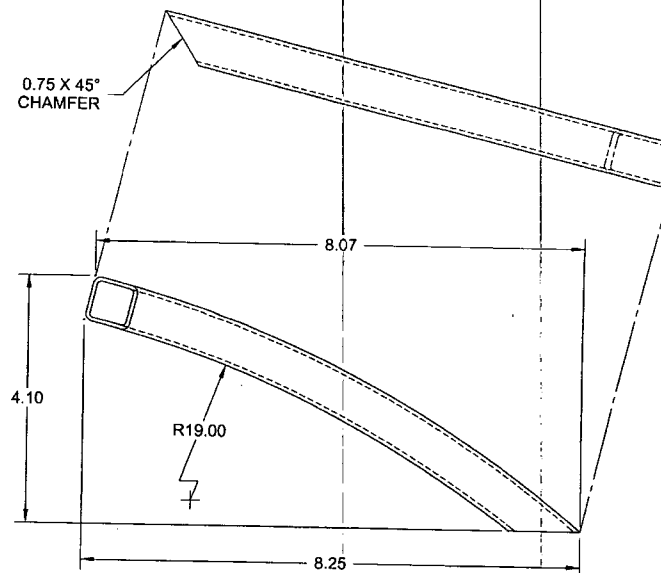
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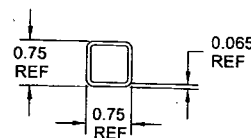
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D2989-3 RIB





D2989-4 RIB



TYPICAL SECTION VIEW

- NOTES:
- 1) MATERIAL: D3166-3 BASKET HOOP
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: D2989-3/-4 = 0.39 lbs;

DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 4 OF 5
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08/11/18 MJD

w/o 58959

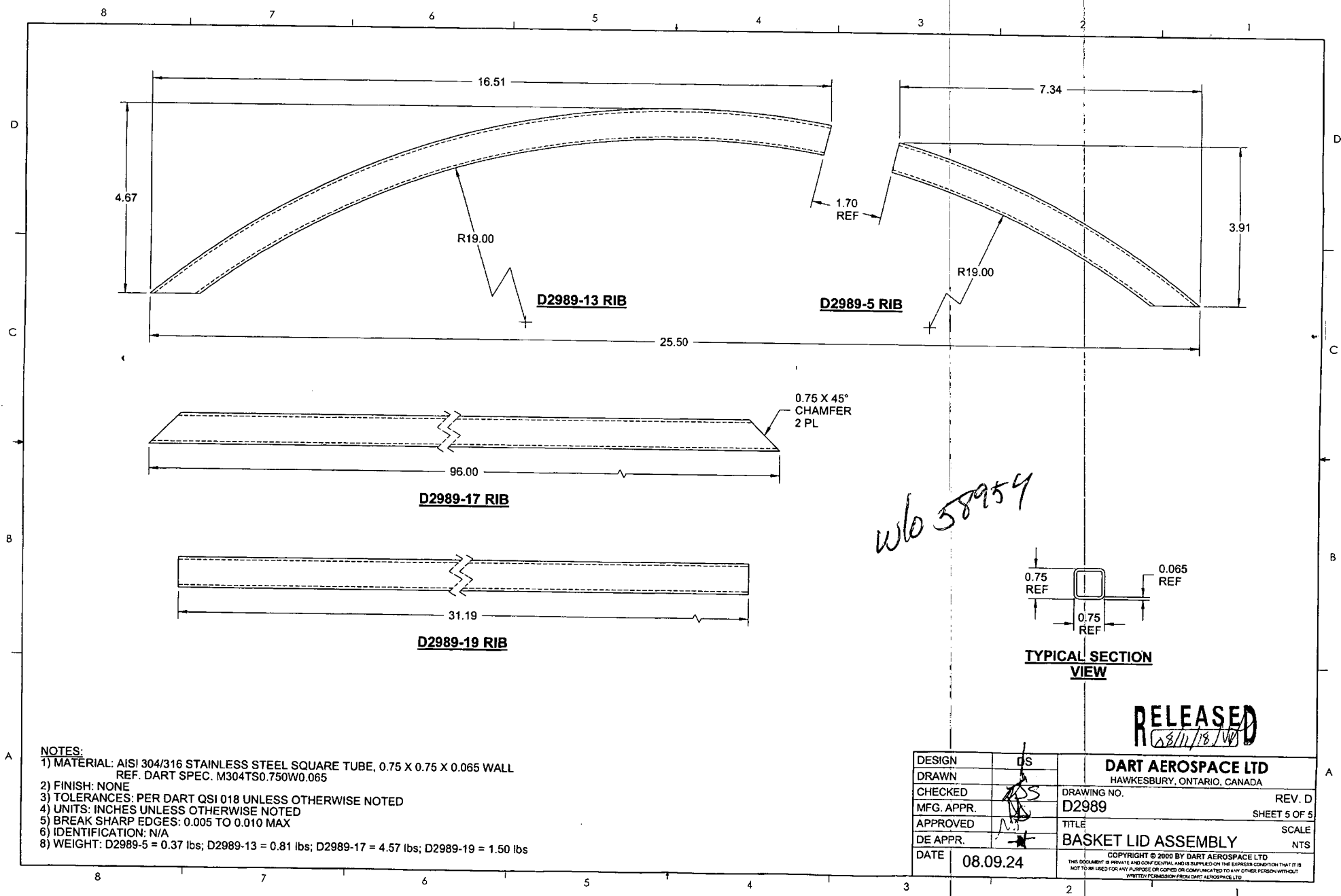
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